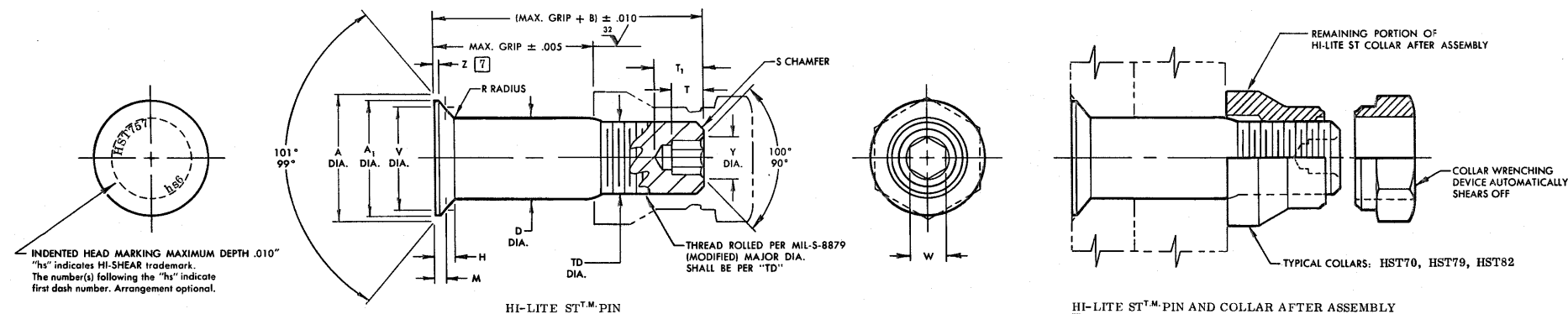


hi-shear
CORPORATION

2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



FIRST DASH NO.	NOM. DIA.	A DIA.	A ₁ DIA. MIN.	B REF.	D DIA.		TD DIA.	F	H REF.	H GAGE PROT.	R RAD.	V GAGE DIA.	Z MAX.	S CHAMFER REF.	THREAD	SOCKET				DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
					WITHOUT SOLID FILM LUBE	WITH SOLID FILM LUBE										W HEX.	T DEPTH	T ₁ DEPTH	Y DIA.		
-5	5/32	.2827	.2617	.280	.1635 .1630	.1635 .1625	.1595 .1570	.004	.049	.0330 .0298	.025 .015	.2028 .2026	.010	1/32" x 45°	8-32UNJC-3A Modified	.0801 .0791	.100 .080	.145	[8]	4,010	1,500
-6	3/16	.3277	.2963	.290	.1895 .1890	.1895 .1885	.1840 .1810	.005	.056	.0295 .0263	.030 .020	.2560 .2558	.015	1/32" x 45°	10-32UNJF-3A Modified	.0806 .0791	.100 .080	.145	.119 .104	5,380	2,400
-8	1/4	.4283	.3969	.320	.2495 .2490	.2495 .2485	.2440 .2410	.006	.074	.0227 .0195	.030 .020	.3732 .3730	.015	1/32" x 45°	1/4-28UNJF-3A Modified	.0967 .0947	.110 .090	.160	.142 .122	9,300	4,500
-10	5/16	.5361	.5047	.380	.3120 .3115	.3120 .3110	.3060 .3020	.007	.092	.0234 .0198	.040 .030	.4791 .4789	.015	3/64" x 45°	5/16-24UNJF-3A Modified	.1295 .1270	.130 .110	.195	.180 .160	14,600	6,850
-12	3/8	.6415	.6101	.420	.3745 .3740	.3745 .3735	.3680 .3640	.008	.110	.0295 .0259	.040 .030	.5698 .5696	.015	3/64" x 45°	3/8-24UNJF-3A Modified	.1617 .1582	.160 .140	.240	.217 .197	21,000	10,200
-14	7/16	.7425	.6941	.485	.4370 .4365	.4370 .4260	.4310 .4260	.009	.126	.0347 .0307	.050 .040	.6582 .6580	.022	3/64" x 45°	7/16-20UNJF-3A Modified	.1930 .1895	.190 .170	.280	.253 .233	28,600	13,100
-16	1/2	.8423	.7939	.525	.4995 .4990	.4995 .4985	.4930 .4880	.010	.142	.0504 .0464	.050 .040	.7200 .7198	.022	3/64" x 45°	1/2-20UNJF-3A Modified	.2242 .2207	.220 .200	.320	.289 .269	37,300	18,000
① -18	9/16	.9300	.8816	.600	.5615 .5610	.5615 .5605	.5550 .5500	.010	.153	.0533 .0485	.050 .040	.8012 .8010	.022	1/16" x 45°	9/16-18UNJF-3A Modified	.2555 .2520	.260 .240	.365	.326 .306	47,200	22,500
① -20	5/8	1.0440	.9956	.640	.6240 .6350	.6240 .6230	.6180 .6120	.010	.174	.0633 .0589	.050 .040	.8902 .8900	.022	1/16" x 45°	5/8-18UNJF-3A Modified	.2555 .2520	.260 .240	.365	.326 .306	58,300	29,200

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

GENERAL NOTES:

- Head edge out of roundness shall not exceed "F."
- Concentricity: Conical surface of head to "D" diameter within .005 FIR.
- "H" is dimensioned from maximum "D" diameter.
- Dimensions in inches and to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Curved or flat edge manufacturer's option.
- Evidence of broken edge across points.
- Use HST857 for oversize replacement.

MATERIAL: A-286 high temperature alloy per Spec. AMS5731 or AMS5737.

HEAT TREAT: 95,000 psi shear minimum at 70°F.

① FINISH: HST757-()-() = Passivate per Hi-Shear Spec. 258 with color black on thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HST757DU-()-() = Solid film lube per MIL-L-8937.

SPECIFICATION: Hi-Lite Product Specification 380.

CODE: First dash number indicates nominal diameter in 1/32nds.
Second dash number indicates maximum grip in 1/16ths.

HOW TO ORDER
EXAMPLES:

Pin Part Number Only
HST757-8-8
8/16 or 1/2 Maximum Grip Length
8/32 or 1/4 Nominal Diameter Pin
Pin Part Number

Pin and Collar Assembly Part Number Combination
HST75770-8-8
Size and Grip Length, See Above Example
Collar Part Number
Pin Part Number

U.S. Patent 4,326,825. Other U.S. and foreign patents pending. "Hi-Lite" and "Hi-Lite ST" are trademarks of Hi-Shear Corporation.

DRAWN		DATE		TITLE	
D. P. S.		11-17-83		HI-LITE ST™ PIN	
APPROVED		DATE		100° FLUSH SPECIAL SHEAR HEAD	
D.P.S.		11-18-83		A-286 HIGH TEMPERATURE ALLOY	
REVISION		DATE		1/16" GRIP VARIATION	
①		D. P. S.		DRAWING NUMBER	
		1-9-84		HST757	

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HST757